



RECALL CAMPAIGN 17V-XXX: FRONT PASSENGER AIR BAG

What's New:

- **Warranty information has been updated**
- **Repair attachment has been updated**

New information provided by this revision is preceded by this symbol .

Please perform the procedure outlined in this Service Information on all affected vehicles before customer delivery. In the event the customer has already taken delivery of the vehicle, please perform the procedure the next time the vehicle is in the shop.

This Service Information bulletin replaces SI B51 01 17 **dated April 2017**

MODEL

F48 (X1 SAV)

SITUATION

An incorrectly manufactured instrument panel may be found in these vehicles. The instrument panel defect may prevent proper airbag expansion in the event of deployment.

Incorrectly manufactured instrument panels are expected to be found in less than 1% of these vehicles.

AFFECTED VEHICLES

Vehicles which require this Recall Campaign to be completed will show it as "Open" when checked either in AIR, the "Service Menu" of DCSnet (Dealer Communication System) or with the Key Reader.

CAUSE

Instrument panel may not have required milling on back side to allow proper airbag expansion, if deployed.

CORRECTION

Inspect back side of instrument panel and replace if required milling is missing.

PROCEDURE

1. Remove glove box as per REP 51 16 366 "Removing and installing the glove box on the right with the housing".
2. Follow attached procedure for "Inspection and/or Replacement of Instrument Panel.

SPECIAL TOOLS

Borescope meeting following specifications (recommended):

- Camera Head Diameter: Preferred diameter $\leq 4.5\text{mm}$. Note: 5.5 mm will suffice.
- Integrated lighting
- Photo function
- Endoscopic Length: 0.7m minimum
- Camera Resolution: 640 x 480 (recommended)

PARTS INFORMATION



Note: Please refer to the Parts Matrix for parts ordering procedure.

Part Number	Description	Quantity
Refer to EPC	Instrument Panel	1
07 14 9 200 938	Clip	13
07 14 8 263 913	Screw, (Instrument panel)	11 (if needed)
07 12 9 907 489	Screw (airbag module)	6 (if needed)



WARRANTY INFORMATION

Reimbursement for this Recall will be via normal claim entry utilizing the following information:

Defect Code:	00 51 15 04 00	
Labor Operation:	Labor Allowance:	Description:
00 65 008	8 FRU	Check the milling for the passenger airbag with borescope (Main work)

Or		
00 65 009	54 FRU	Check the milling for the passenger airbag with borescope and replace Dash Board (Main work).
Or		
00 65 513*	7 FRU	Check the milling for the passenger airbag with borescope (Plus work)
Or		
00 65 514	53 FRU (AUTO)	Check the milling for the passenger airbag with borescope and replace Dash Board (Plus work)

ATTACHMENTS

View PDF attachment [Attachment A - Inspection and Repair Instructions_V2](#).

View PDF attachment [B511717 Recall Notice](#).

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SAFETY RECALL NOTICE

To: All Center Operators, Sales Managers, Service Manager, Parts Manager and Warranty Processor

RE: Delivery Stop & Recall 17V-XXX: Check and Replace Instrument Panel B51 17 17

BMW Group is conducting a Voluntary Safety Recall (effective April 3, 2017) on Model Year 2016 – 2017 BMW X1 SAV vehicles involving the instrument panel.

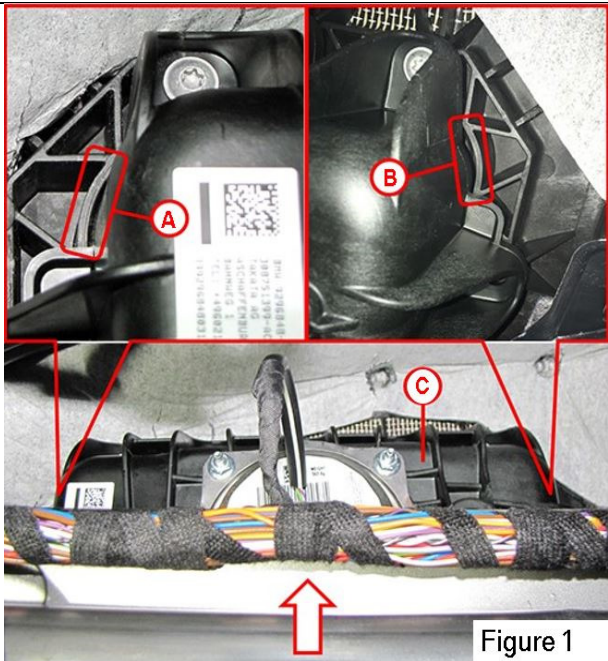


Owners will be notified by First Class mail about the Recall and will be instructed to bring their vehicles in for a free repair when parts are available.


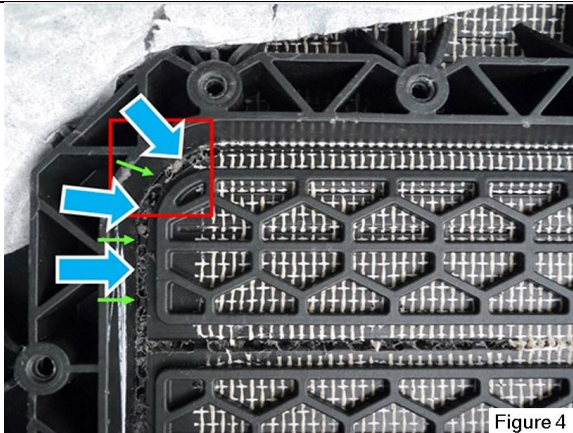

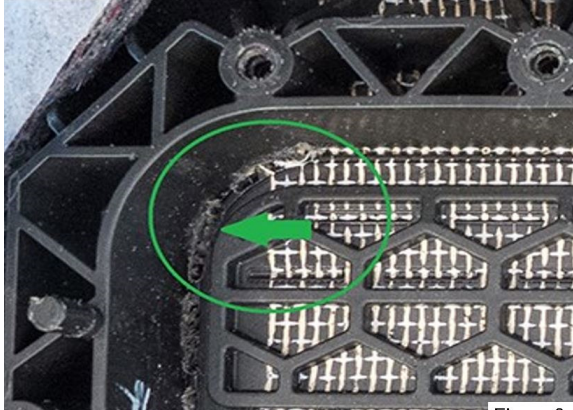
Please be reminded that it is a violation of federal law (The Safety Act) for you to sell, lease or deliver any new motor vehicle covered by this notification until the recall repair has been performed. This means that centers may not legally deliver new motor vehicles to consumers until they are fixed or use/sell replacement equipment/parts subject to this recall. Note also that substantial civil penalties apply to violations of the Safety Act.

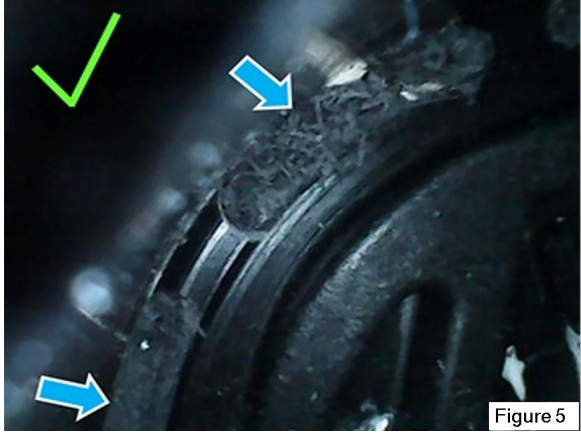
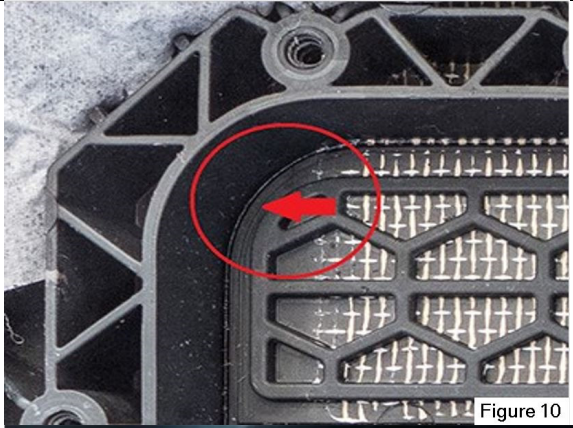


Also, you should not sell, lease or deliver any Certified Pre-Owned or used vehicles subject to a safety recall until the repair is completed.

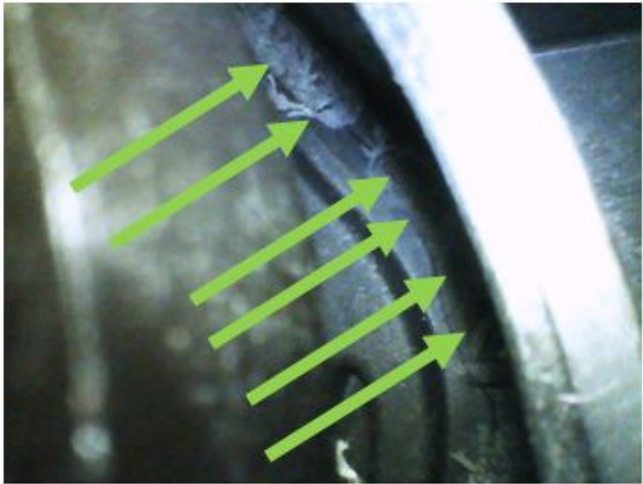
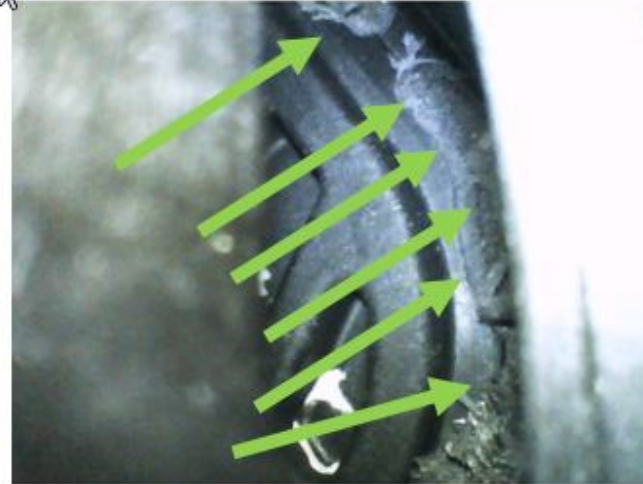
Please follow any special instructions that we provide to you for the return or disposition of recall parts.

We appreciate all your assistance with this Recall.

		Remove glovebox to inspect passenger side instrument panel air bag area. Refer to repair instructions REP 51 16 366 "Removing and installing the glove box on the right with the housing".
 <p>Figure 1</p>		<p>1. Overview:</p> <p>Once the glovebox has been removed, the rear of the passenger side airbag will be visible (C). At points A and B, there are gaps through which the milling points can be viewed using a borescope.</p> <p>Note: The inspection must be performed on both sides of the instrument panel at points A and B.</p>
 <p>Figure 2</p>		<p>2. Position the camera head of the endoscope as shown in Fig. 2 at the gap and, if necessary, rotate camera head until a useful image is displayed.</p> <p> Note: Due to manufacturing tolerances, the gap on the right and left can be of different sizes. When using borescope, move the camera head to the largest part of the gap. The camera head of the endoscope does not fit entirely into the gap.</p>

 <p>Figure 3</p>	<p>3. Move borescope to the other side and test at the largest part of the gap. Rotate camera head until a useful image is displayed (The image should be similar to Figure 5 or 6).</p>
 <p>Figure 4</p>	<p>4. Figure 4 shows the correct milling of the instrument panel. The area in the red square is the approximate area which will be viewable with the borescope. Blue arrows showing milling and the green arrows show milling jigs.</p> <p> Note: Figure 4 shows the underside of the instrument panel with the passenger side airbag removed. Your view will be what is shown in Figure 5.</p>
 <p>Figure 8</p>	<p>5. Figure 8 shows a closer view of the area to be inspected.</p>

 <p>Figure 5</p>	<p>6. In figure 5, the image shows the view via the borescope. The milling area shown (indicated by the blue arrows) is correctly done. If the milling is correct on both side, the vehicle can be reassembled and no further actions is needed. Refer to repair instructions 51 16 366 "Installing the glove box on the right with the housing".</p>
<p>x</p>  <p>Figure 10</p>  <p>Figure 6</p>	<p>7. Figure 10 shows the incorrect milling of the instrument panel. If there is no groove on the image of the borescope and no milling traces as in Fig. 6, then the instrument panel must be replaced. Refer to repair instructions "51 45 031 Replace cover for instrument panel". Note: Only in emergencies when no borescope is available, the instrument panel needs to be removed to inspect the milling area. Refer to repair instructions "72 12 000 Removing and installing the airbag module on the passenger side". .</p> 

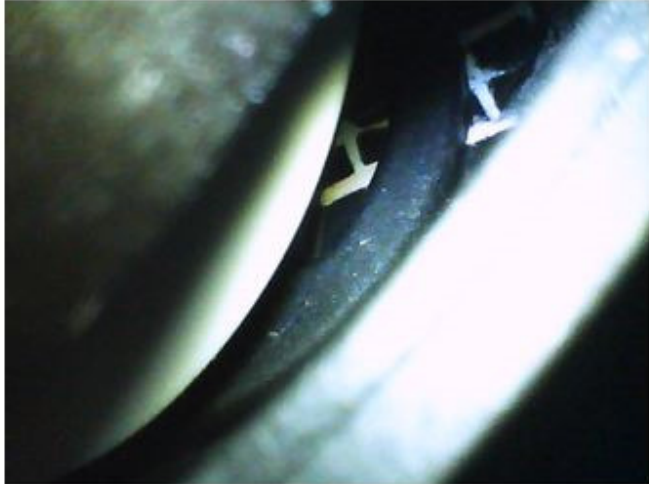

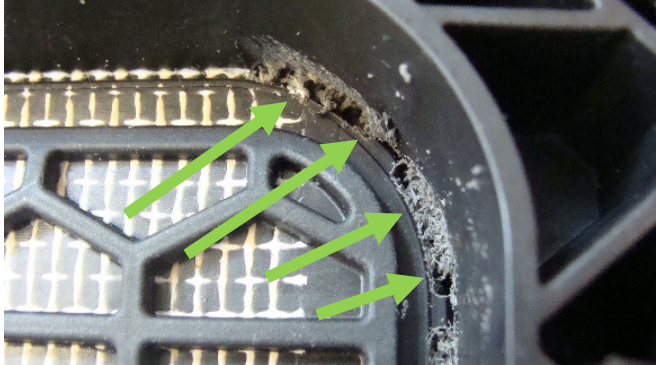
 <p data-bbox="215 790 861 828">Evidence of correct milling – Green arrow</p>	<p data-bbox="997 286 1390 387">8. The following pictures are for clarification to help interpret your borescope images.</p>
 <p data-bbox="215 1395 901 1433">Evidence of correct milling – Green arrow</p>	

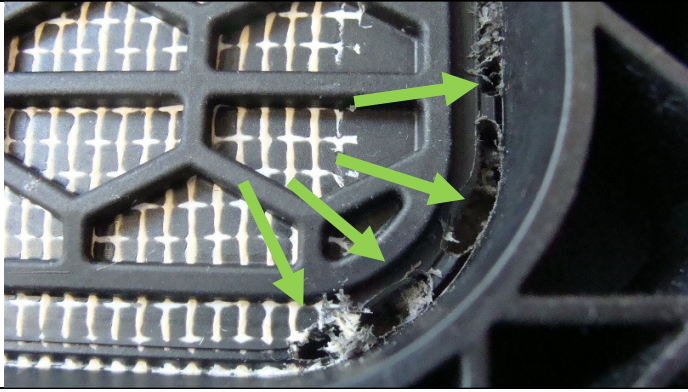


Evidence of correct milling – Green arrow



Evidence of correct milling – Green arrow

 <p data-bbox="215 784 866 840">Unable to determine (wrong angle view)</p>	<p data-bbox="997 286 1390 526">9. The image at the left if showing the wrong angle view. The evidence of milling cannot be determined. The borescope must be put at a less extreme angle to obtain correct image.</p>
 <p data-bbox="311 1176 758 1209">Green areas show correct milling</p>	<p data-bbox="997 896 1364 1064">10. The image at left shows the milling marks (green arrow) with the airbag removed from the dashboard (this is for reference only).</p>
	<p data-bbox="997 1433 1364 1601">11. The image at left shows the milling marks (green arrow) with the airbag removed from the dashboard (this is for reference only).</p>

	<p>12. The image at left shows the milling marks (green arrow) with the airbag removed from the dashboard (this is for reference only).</p>